



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2873-043
Job Sheet 211085



Part No: D2873-043

Job Qty: 100 pcs

Part Name: Nut Plate Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/3/20

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 9/21/20

Type: SOLD

Description:

Note: DWG REV A IPP A 05.09.13 New issue KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	100 pcs	9/18/20		0.00	0.48	Bandsaw - 1		DAS 33 20/09/13
110	HAAS 4 Axis - B4B	100 pcs	9/19/20		0.04	26.38	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		DAS 33 20/09/13
							HAAS - 4 - B4B		9-89
120	QC 2	100 pcs	9/19/20		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		DAS
							QC 2 - 33		33 20/09/13
							QC 2 - 35		9-89
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		



Container No: S299930



Part: D2873-043

Job No: 211085

Serial No/Batch: S299930

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 09/13/20

Plex 7/3/20 10:19 AM Dart.lajeunesse.marie

				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 2 - 86	
				QC 2 - 83	
130 QC 8	100 pcs	9/19/20	0.00 0.00	QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	DAS
				QC 8 - 52	52
				QC 8 - 23	9-89
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
				QC 8 - 66	
				QC 8 - 73	
				QC 8 - 82	
150 QC 5	100 pcs	9/19/20	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				Plex 7/3/20 10:19 AM Dart.lajeunesse.marie	

NOT REQUIRED

OCT 17 2020

DAS
52
9-89

160 Handfinish - 1-1 Chemical-B4B	100 pcs	9/19/20	0.00	1.25	QC 5 - 61						
					QC 5 - 81						
					QC 5 - 82						
					Handfinish - 1 - 1 - B4B						
					Handfinish - 1 - 2 - B4B						
					Handfinish - 1 - 3 - B4B						
					Handfinish - 1 - 4 - B4B						
					Handfinish - 1 - 5 - B4B						
					Handfinish - 1 - 6 - B4B						
					Handfinish - 1 - 7 - B4B						
					Handfinish - 1 - 8 - B4B						
					Handfinish - 1 - 9 - B4B						
					Handfinish - 1 - 10 - B4B						
					Handfinish - 1 - 11 - B4B						
					Handfinish - 1 - 12 - B4B						
					Handfinish - 1 - 13 - B4B						
					Handfinish - 1 - 14 - B4B						
					Handfinish - 1 - 15 - B4B						
					Handfinish - 1 - 16 - B4B						
					Handfinish - 1 - 17 - B4B						
					Handfinish - 1 - 18 - B4B						
					Handfinish - 1 - 19 - B4B						
					Handfinish - 1 - 20 - B4B						
					Handfinish - 1 - 21 - B4B						
					Handfinish - 1 - 22 - B4B						
170 QC 7	100 pcs	9/19/20	0.00	0.00	QC 7 - 10	JW 2020/09/30					
					QC 7 - 13						
					QC 7 - 14						
					QC 7 - 15						
					QC 7 - 17						
					QC 7 - 18						
					QC 7 - 19						
					QC 7 - 2						
					QC 7 - 28						
					QC 7 - 3						
					QC 7 - 30						
					QC 7 - 34						
					QC 7 - 36						
					QC 7 - 37						
					QC 7 - 41						
					QC 7 - 47						
					QC 7 - 48						
					QC 7 - 51						
					QC 7 - 58						
					QC 7 - 59						
					QC 7 - 60						
					QC 7 - 9						
					QC 7 - 68						
					Plex 7/3/20 10:19 AM Dart.lajeunesse.marie						

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					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
					QC 7 - 76	
					QC 7 - 79	DAS 81
					QC 7 - 83	9-89
					QC 7 - 82	
					QC 7 - 87	DAS
180	Small Fab - 2 - B4B	100 pcs	9/21/20	0.00 3.39	Small Fab - 1 - B4B	58 OCT 01 2020
					Small Fab - 2 - B4B	9-89
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
					Small Fab - 8 - B4B	
					Small Fab - 9 - B4B	
					Small Fab - Various 1 - B4B	
190	QC 5	100 pcs	9/21/20	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	DAS 82
					QC 5 - 61	9-89
					QC 5 - 81	
					QC 5 - 82	OCT 07 2020
200	Packaging 3-1 - Stock - B4B	100 pcs 134 pcs. MLO	9/21/20	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	DAS 28
					Packaging 3 - 5 - B4B	9-89
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	OCT 07 2020
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	

				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
210 QC 21 - SA	100 pcs	9/21/20	0.00 0.00	QC 21 - SA - 21	DAS 21 OCT 07 2020
				QC 21 - SA - 70	0.00
				QC 21 - SA - 9	
				QC 21 - SA - 77	

Part Op 100 - Cut blanks: 1.000" x 0.375" x 3.700" long
 Descriptions: 110 - (HAAS CNC Vertical Machine) Machine as per Folio FA and Dwg D2873 Identify as D2873-3 Dwg Rev ____ Folio Rev ____
 120 - (QC2- Inspect parts off machine FAI/FAIB)
 130 - (QC8- Inspect parts - second check)
 150 - (QC5- Inspect part completeness to step on W/O)
 160 - (Chemical Conversion Coat per QSI005 4.1)
 170 - (QC7-Inspect Chemical Conversion Coat)
 180 - 1-Assemble as per Dwg D2873 2-Identify as D2873-043
 190 - (QC5- Inspect part completeness to step on W/O)
 200 - (Identify as per dwg & Stock Location: _____) LOCATION : LG050
 210 - (QC21- Final Inspection - Work Order Release)

077665

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.375X1.000	6061T6 Bar .375 X 1.00	30.8300 ft (.3083 ea)	100-Bandsaw - 1	5299409 / 5290848
MS20426AD4-5	Rivet	600 Ea (6 ea)	180-Small Fab - 2 - B4B	5087872
MS21075L5	Nut Plate	300 Ea (3 ea)	180-Small Fab - 2 - B4B	5087905 y30

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B0.375X1.000	31	0	0
180-Small Fab - 2 - B4B	MS20426AD4-6	600	1,195	0
	MS21075L5	300	43	0

Part Specifications

Specifications could not be found.

DART AEROSPACE LTD		Work Order:	211085
Description: Radius Block		Part Number:	D2873-3
Inspection Dwg: D2873 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.50	+/-0.030	3,500	✓		HJP-04	vern
2.000	+/-0.010	2,000	✓			
0.750	+/-0.010	0,748	✓			
1.000	+/-0.010	1,000	✓			
0.250	+/-0.010	0,247	✓			
1.000	+/-0.010	1,000	✓			
2.000	+/-0.010	2,000	✓			
3.000	+/-0.010	3,000	✓			
Ø0.128	+0.005/-0.001	0,130	✓			
0.359	+/-0.010	0,356	✓			
Ø0.316	+0.006/-0.001	0,317	✓			
1.000	+/-0.010	0,998	✓			
0.250	+/-0.010	0,246	✓			
0.061	+/-0.010	0,060	✓			
Ø0.230 x 0.125	+0.005/-0.001 x 0.010	0,118	✓			

Measured by: DAS 33	Audited by: DAS 52	Prototype Approval:	N/A
Date: 20/09/09	Date: 20/09/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue P/O D2873-043	KJ/JLM	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					